

Date: Monday, 1/8/2007 10:50:39 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30151
 Estimate Number : 10960
 P.O. Number : N/A
 This Issue : 1/8/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 28128
 Written By :
 Checked & Approved By : JA 07.01.08
 Comment : Est. A 990113 New Issue DM/DS

Drawing Name : JET
 Part Number : D2000043
 Drawing Number : D2000 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 1/30/2007
 Qty: 32 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6H0625 6061-T6 5/8" HexBar



Comment: Qty.: 0.2975 f(s)/Unit Total : 9.5189 f(s)

6061-T6 5/8" HexBar

Batch: 1102034

2.502/27/29

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA653 & DWG D2000-043 ,

FOLIO REV: M

DWG REV: B

2-DEBURR AS REQUIRED

2.507/03/30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2.507-09-18

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine as per Folio FA653 and Dwg D2000--043

2.507-09-18

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2.507-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JET

Job Number: 30151

Part Number: D2000043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



counted

Comment: SECOND CHECK

E 07/09/18 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *572*

E 07/09/18 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/19

Job Completion



U 07-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30151
Description: Jet		Part Number:	D2000-043
Inspection Dwg: D2000-043 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.245	+/-0.010	3.246	✓			
2.745	+/-0.010	2.755	✓			
0.845	+/-0.010	0.849	✓			
2.150	+/-0.010	2.147	✓			
0.670	+/-0.010	0.673	✓			
Ø0.310	+0.006/-0.001	0.312	✓			
Ø0.375	+0.006/-0.001	0.375	✓			
Ø0.110	+0.004/-0.001	0.111	✓			
Ø0.191	+0.005/-0.001	0.196	✓			
0.625	+/-0.010	0.625	✓			
0.475	+/-0.010	0.475	✓			
0.245	+/-0.010	0.245	✓			
0.025	+/-0.010	0.025	✓			
OD of 9/16" - 18	0.550" - 0.560	0.556	✓			
MOW 0.566	+/-0.005	0.567	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07-09-18	Date: 07/09/18	Date:	N/A

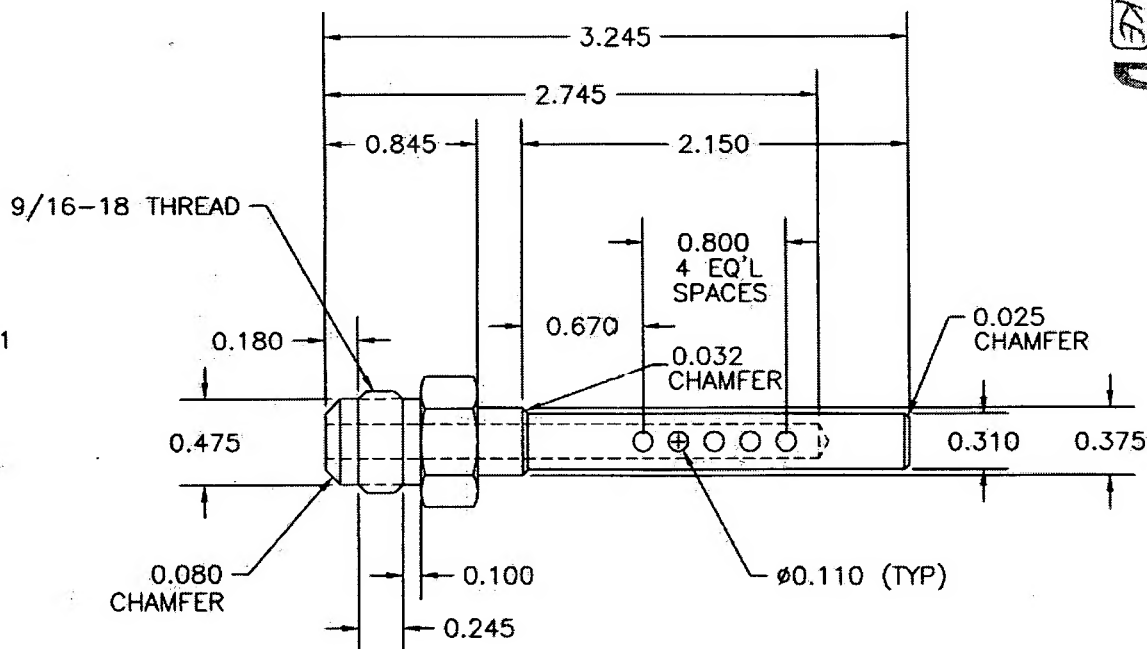
Rev	Date	Change	Revised by	Approved
A	06.10.18	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART



RELEASED
990113 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED JP	DRAWING NO.
DATE 98.12.18		D2000-043
		SHEET 1 OF 1
		SCALE
		1:1
A	90.04.02	NEW ISSUE
B	98.12.18	REDRAWN ON SEPARATE SHEET NOW MACHINED PIECE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30151

MATERIAL: 6061-T6 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
FINISH: NONE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED